

Work Order ID 51278

August 13, 2009 10:55:36 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CDL

Date: 09/08/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

D

11/9/124

Work Order ID 51278

August 13, 2009 10:55:36 AM



Page 2

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Start Date: 8/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

① MB 09.08-25

=> 8 09/08/25

②

/

Work Order ID 51278

August 13, 2009 10:55:36 AM



Page 3

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Setup Start



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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

mull682 BE 07/04/26

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

mull682 BE 07/08/26

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

AWM
-9-8-27

Work Order ID 51278

August 13, 2009 10:55:36 AM



Page 4

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00 ⇒ 509/08/08							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 ⇒ 509/08/08							
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00 ⇒ 509/08/31							

Work Order ID 51278

August 13, 2009 10:55:36 AM

Page 5

Item ID: D205-634-041

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Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00

Required Date: 10/13/09 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

112260

0.00

Powder Coating

START TIME:

2:40pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:10pm

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-09-2

JL 09-08-31

Work Order ID 51278

August 13, 2009 10:55:36 AM



Page 6

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐☐☐ Sikaflex-291 M/112391 ☐☐☐
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐☐☐ Sikaflex-291 M/112391 ☐☐☐
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M/112106

14 09-09-3

Work Order ID 51278

August 13, 2009 10:55:36 AM

Page 7

Item ID: D205-634-041

Accept

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00

Required Date: 10/13/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

22 Scales

Ⓢ

Ⓢ

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

PPP

51489

2/9/28 WSP

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/30

Quality Control

u 09.09.30

Picklist Print

August 13, 2009 10:55:35 AM

Page 1

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2580-1RevD

Manufactured

No

110

Each

8.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

6

50757

6

Main Warehouse

ST

2

50758

2

D 11918124

D2576-3RevG

Manufactured

No

140

Each

147.0000

1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

147

43504

46

46661

101

1 BE 07/08/26

Picklist Print

August 13, 2009 10:55:35 AM

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	92.0000	20.0000			



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		92	
43988		4	
46434		4	
46956		2	
47797		28	
48272		54	

B51315 (20) B6 09/03/26

D2855RevA

Manufactured No

200

Each

37.0000

1.0000



Cap

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
FP6		37	
50513 ✓		37	

1 B6 09-09-3.

Picklist Print

August 13, 2009 10:55:35 AM

Page 3

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			200	Each	2,540.000	2.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2540

100188 ✓

226

105057

2246

15205

68

2 BR 09-09-3.

AN960JD10L

Purchased

No

200

Each

6,733.000

2.0000



Washer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6733

101291

16

104885

153

105793

236

109632 ✓

1328

110985

5000

2 BR 09-09-3.

August 13, 2009 10:55:35 AM

Shop Packet Print

Page 3

Picklist Print

August 13, 2009 10:55:35 AM

Page 4

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3628
105855	16
108606	52
111529	1560
111779 ✓	2000

AN3C4A

Purchased

No

200

Each

1,222.000

50.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1222
112082	40
112314 ✓	1182

50 BR 09-09-3.

BR 09-09-3.

August 13, 2009 10:55:35 AM

Shop Packet Print

Page 4

Picklist Print

Page 5

August 13, 2009 10:55:35 AM

Work Order ID: 51278



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 8/13/09

Required Date: 10/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L		Purchased	No			200	Each	3,764.000	50.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



washer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

OFFSHORE

FG	100	
----	-----	--

103585	100	
--------	-----	--

Main Warehouse

ST	3664	
----	------	--

112116 ✓	3664	
----------	------	--

50 BR 09-09-3

D3566-13RevC

Manufactured No

200	Each	29.0000	1.0000
-----	------	---------	--------



Gasket



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	29	
----	----	--

45717	1	
-------	---	--

46889	2	
-------	---	--

48166	10	
-------	----	--

50265 ✓	16	
---------	----	--

1 BR 09-09-3.

August 13, 2009 10:55:35 AM

Shop Packet Print

Page 5

Picklist Print

August 13, 2009 10:55:35 AM

Page 6

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3566-5RevC

Manufactured

No

200

Each

4.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51260

4

36113

1

46186

1

47318

1

48167

1

1 BR 09-09-3.

D3566-1RevC

Manufactured

No

200

Each

13.0000

2.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46349

1

47434

2

48557

3

51218

7

51254
51612

1 BR 09-09-3.
1 BR 09-09-3.

August 13, 2009 10:55:35 AM

Shop Packet Print

Page 6

Picklist Print

August 13, 2009 10:55:35 AM

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 8/13/09

Required Date: 10/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-11RevD

Manufactured

No

200

Each

15.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

45823

48553

50112

15

1

4

10

200

Each

39.0000

1.0000

D3564-13RevD

Manufactured

No



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP17

48554

50270 ✓

24

2

22

Main Warehouse

ST

45409

46495

47867

15

3

10

2

1 BX 09-09-3

1 BX 09-09-3

Picklist Print

August 13, 2009 10:55:35 AM

Page 8

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	3.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51258

1 BL 09-09-3.

ST

3

44659

1

45825

1

48556

1

D3564-5RevD

Manufactured No

200

Each

6.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

OFFSHORE

51257.

1 BL 09-09-3

FG

2

34806

2

Main Warehouse

FP19

2

48555

2

Main Warehouse

ST

2

45824

1

47433

1

August 13, 2009 10:55:35 AM

Shop Packet Print

Page 8

Picklist Print

August 13, 2009 10:55:35 AM

Page 9

Work Order ID: 51278

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2594-3RevC

Manufactured

No

200

Each

670.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

670

27168

44

29908 ✓

626

D2594-1RevC

Manufactured

No

200

Each

476.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

476

42221

16

42807

92

43884

3

46435

2

47251 ✓

363

16 09-09-3

16 09-09-3

August 13, 2009 10:55:35 AM

Shop Packet Print

Page 9

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51278

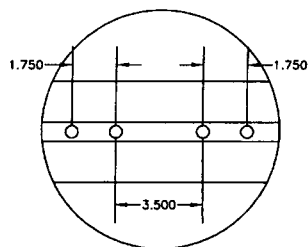
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL \varnothing 0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

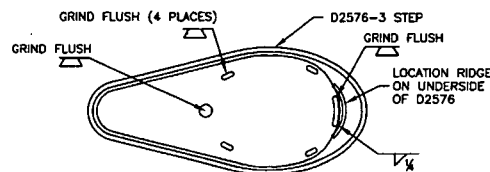
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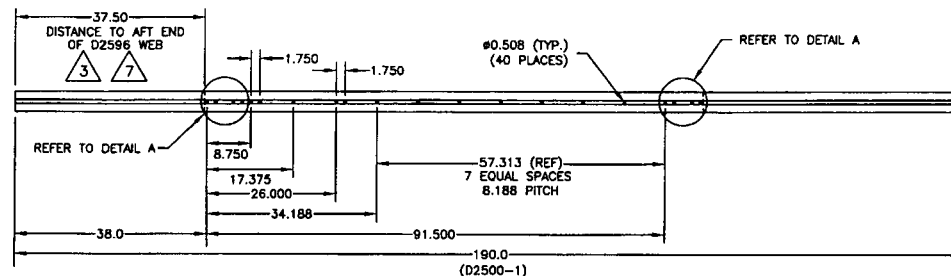
DETAIL A
SCALE 5:24



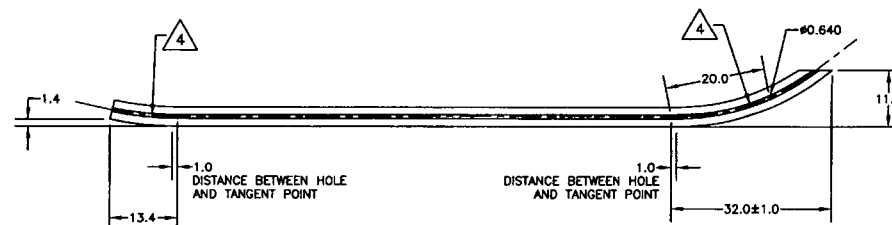
DETAIL B
SCALE 5:24



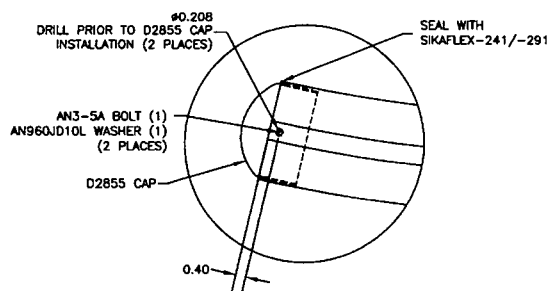
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL

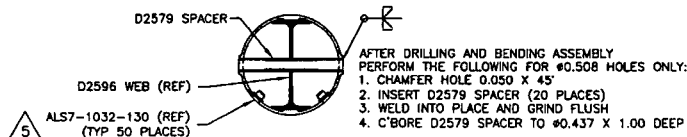


DETAIL C
SCALE 5:24

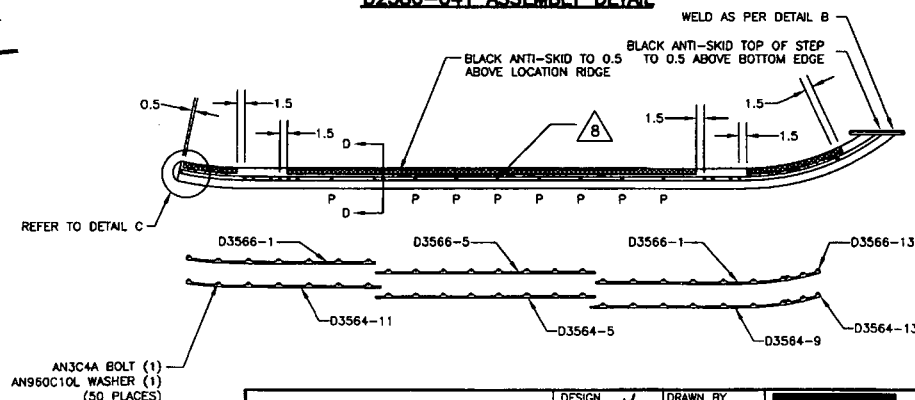


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SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

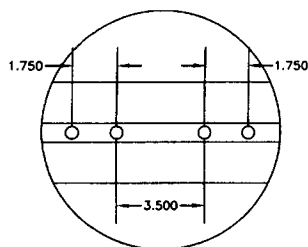
- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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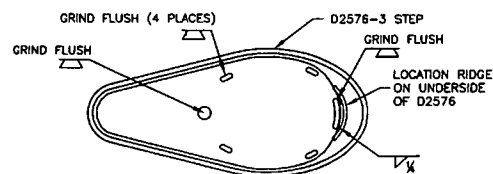
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE	TITLE	D2580	SHEET 2 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY	SCALE	1:24

DETAIL E
SCALE 5:24

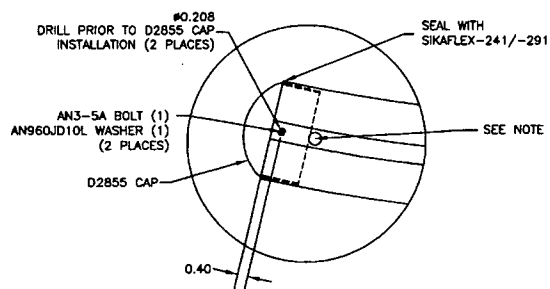


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07.06.28

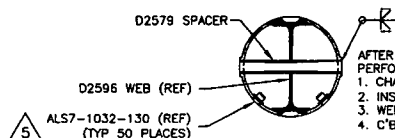
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

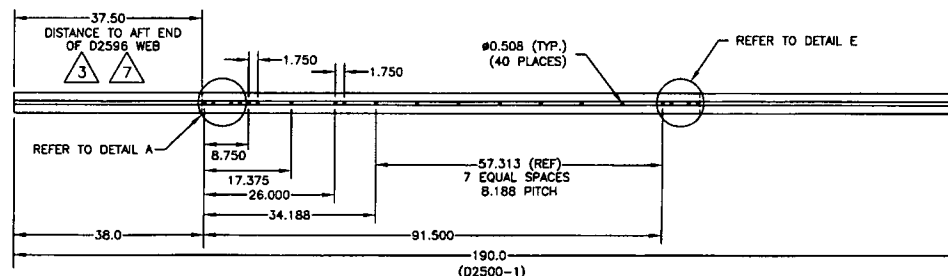


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

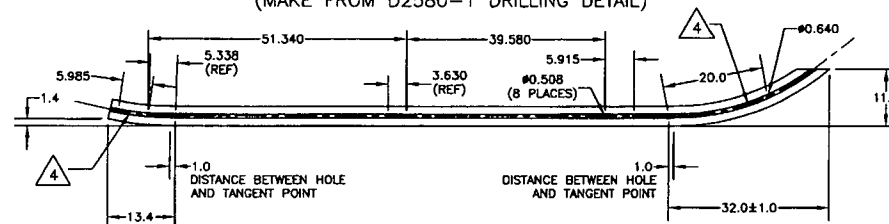
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

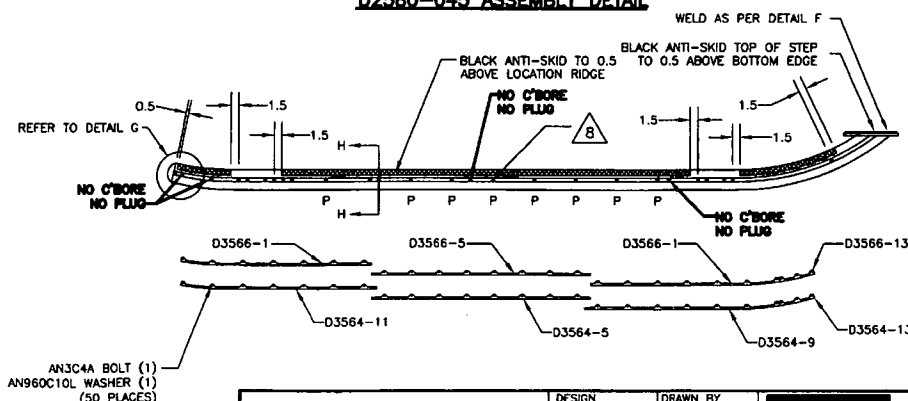
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DATE	TITLE	D2580	SHEET 3 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY		SCALE 1:24

NO. 207

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliott
Job number: 50849
Part number: D205-634-041
Description: 205 sk. tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.08.27

Welder [Signature] Date of Test Coupon 09.08.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld